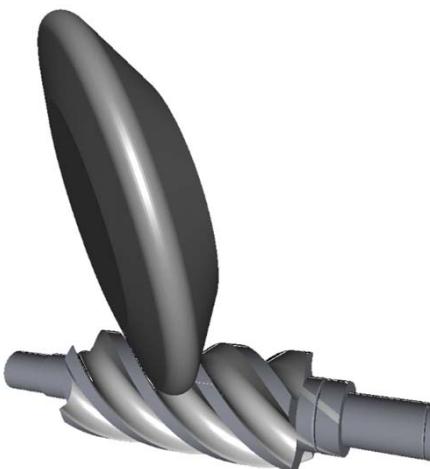


Compressor Rotor Ø116 Z5

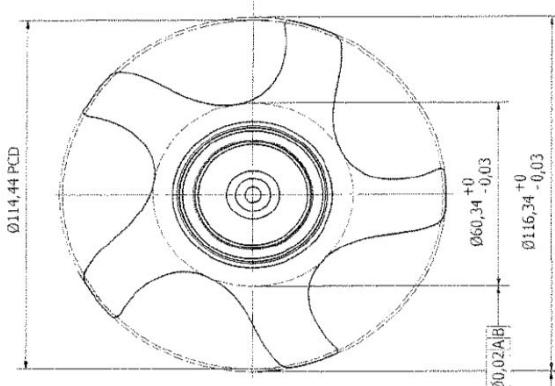
A30-200

Material removal in Pregrinding is 0.03 mm per pass, total removal 1 mm. For finishing 5 passes with partial increment of 0.005 mm are executed.



1. Cycletime for Production

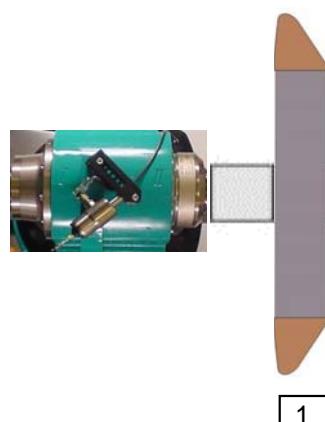
Workpiece: Ø 116 mm, Z 5, Length 225 mm, Helix 338 mm Material GGS				
Operations	Dress	Flute pregr	Dress	Flute fin
Feed [mm/Min]	150	2000	150	3000
Power [kW]	3	25	3	20
Cutting feed [m/s]	34	34	34	34
Used wheels	1	1	1	1
Grinding time [s]	164	2991	164	910
Total cycle time	70 Min 29			



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 DXF Ø450-500 C80



1

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS C500 Coolant: Synthetic Oil, pressure 16 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories: Dressing Unit

Responsible engineer: OP. 3.8.10

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY
FOR TOOLING